

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027071**Date Inspected:** 26-Jan-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernard Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Emergency Gates CCO-179**Summary of Items Observed:**

Emergency Gate Installation associated with CCO-179

The Caltrans Quality Assurance (QA) Inspector Rick Bettencourt arrived on site at the Skyway Bike Path to randomly observe the American Bridge/Fluor personnel install the Emergency Gates associated with CCO-179. Gate 6 to rail 6

The QA Inspector randomly observed the ABF welder Jason Collins and ABF representatives Bradley Whitburn and Mathew Chamberlin fit up gate retainer, gate latch and stainless steel gate track at the above identified location. The QA Inspector noted the hardware had been previously placed at the location and the paint and galvanized coating had been removed on the existing rail for installation of the emergency gate hardware. The QA Inspector randomly observed the ABF welder fit up and tack weld the gate retainer bracket and gate latch to the existing rail. After they were tack welded in place the gate track was positioned for drilling and tapping the holes for the installation of the stainless steel screws. Once the gate was moving free and clear, the SE QC Inspector performed a visual inspection of the fit up. The QC Inspector informed the QA Inspector the fit up was acceptable. The QA Inspector performed a random visual inspection of the fit up and noted it did appear to be in general compliance with the contract documents for the exception of the stainless steel gate tracks welds.

The QA Inspector observed the ABF welder Jason Collins perform shielded metal arc welding (SMAW) of the restrainer bracket and gate latch for the above identified location. The QA Inspector noted the ABF welder was utilizing 1/8" E7018 low hydrogen electrodes with 122 Amps. The QA Inspector noted the SMAW parameters did appear to be in general compliance with the contract requirements. The QA Inspector noted the ABF personnel did not complete the installation of the above identified emergency gate on this date.

WELDING INSPECTION REPORT

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Summary of Conversations:

noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
